

Work Order ID 50694

July 21, 2009 9:57:54 AM



Page 1

Item ID: D3294-5

Revision ID: C

Item Name: Doubler

Start Date: 7/21/09

Start Qty: 12.00

Required Date: 7/22/09

Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3294

Dwg Rev: E

Prog Rev: E

IB 9-7-21

grain direction as per dwg D3294 **

2-Deburr if necessary

(14)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

IB 9-7-21

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Item ID: D3294-5

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Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Memo
1- Deburr if necessary
2- Bend as per Dwg D3294

0.00



Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control



⇒ 807/4/22

(14)

φ

809/6/22

14

φ

⇒ 807/4/22

(14)

φ

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Item ID: D3294-5

Accept



Setup Start



Revision ID: C

Stop



Item Name: Doubler

Start Date: 7/21/09

Start Qty: 12.00



Cust Item ID:

Required Date: 7/22/09

Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

BK 09-07-23

(14)

Memo

0.00

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

EP 09/07/27 (14)

170



Packaging

Packaging

Identify as per dwg & Stock Location: 6-A

0.00

Memo

0.00

EP 09/07/27 (14)

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Item ID: D3294-5

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Item Name: Doubler

Start Date: 7/21/09

Start Qty: 12.00

Required Date: 7/22/09

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Accept



Setup Start



Stop



Cust Item ID:

Customer:

09/07/28 *[Signature]*

MF 09-07-27

[Handwritten mark]

Picklist Print

July 21, 2009 9:57:54 AM

Work Order ID: 50694

Parent Item: D3294-5RevC

Parent Item Name: Doubler

Comments:



Start Date: 7/21/09

Required Date: 7/22/09

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	85.1198	0.8211			



2024-T3 .080 sheet

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT	85.11978947	
104921	3	
105411	17	
107460	4.36	
110347	11.3297895	
110908	39.93	
15628	6	
17695	1.5	
18481	2	

110908 139-7-21

DART AEROSPACE LTD		Work Order:	50694
Description: Doubler		Part Number:	D3294-5
Inspection Dwg: D3294-5 Rev: C		Page 1 of 1	

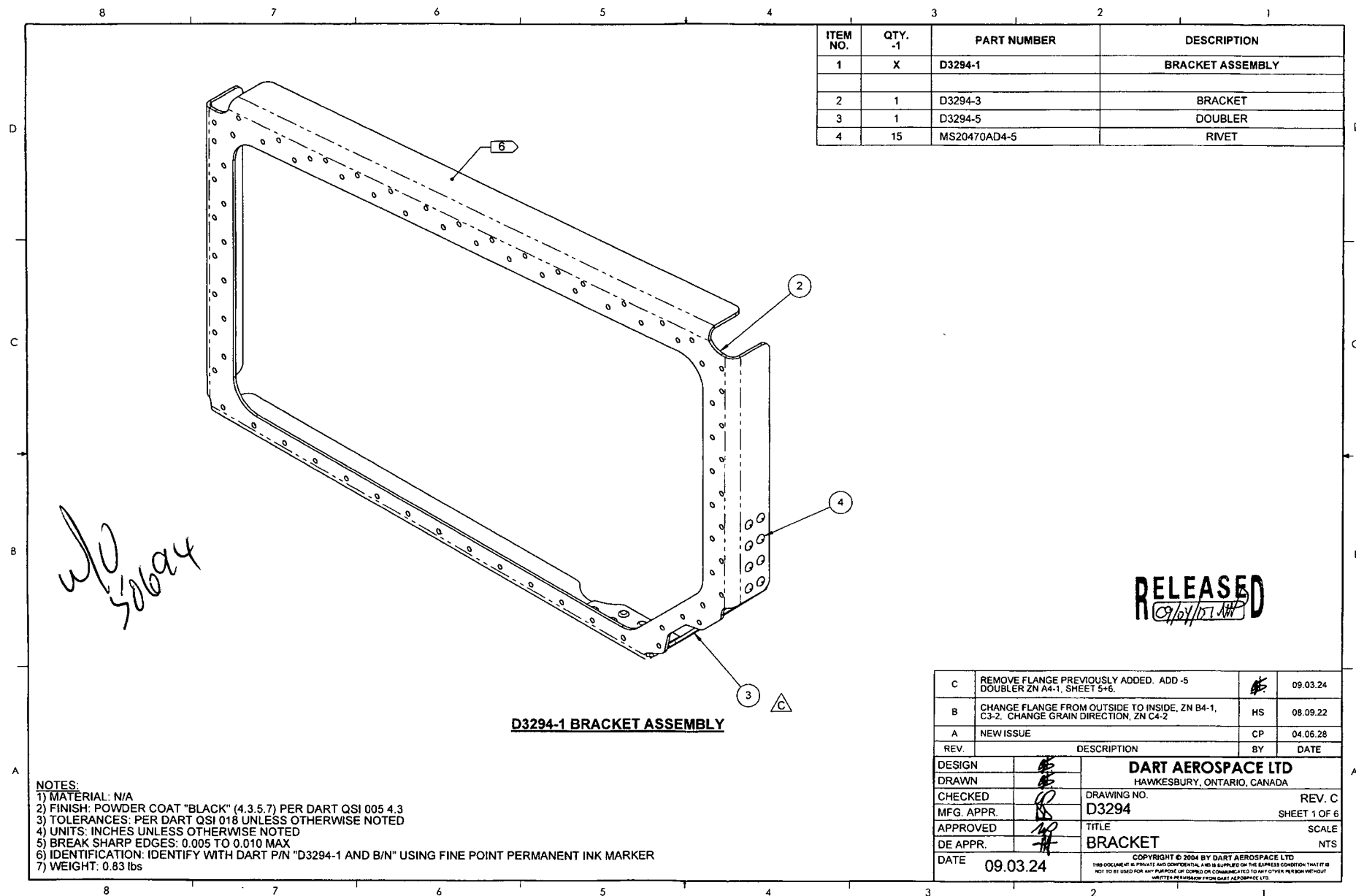
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.131	X			
.165	± .030	.165	✓			
.30	± .030	.30	✓			
.53	± .030	.53	✓			
3.36	± .030	3.345	✓			
2.50	± .030	2.501	✓			
.15	± .030	.15	✓			
9.21	± .030	9.264	✓			
.400	± .010	.402	✓			
B 1.90	± .030					
.300	± .010	.300	✓			
.30	± .030	.30	✓			
.625	± .010	.626	✓			
.080	± .010	.078	✓			
1.00	± .030	1.003	✓			

Measured by: IB	Audited by: S	Prototype Approval: n/
Date: 9-7-21	Date: 09/07/22	Date: 9








Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



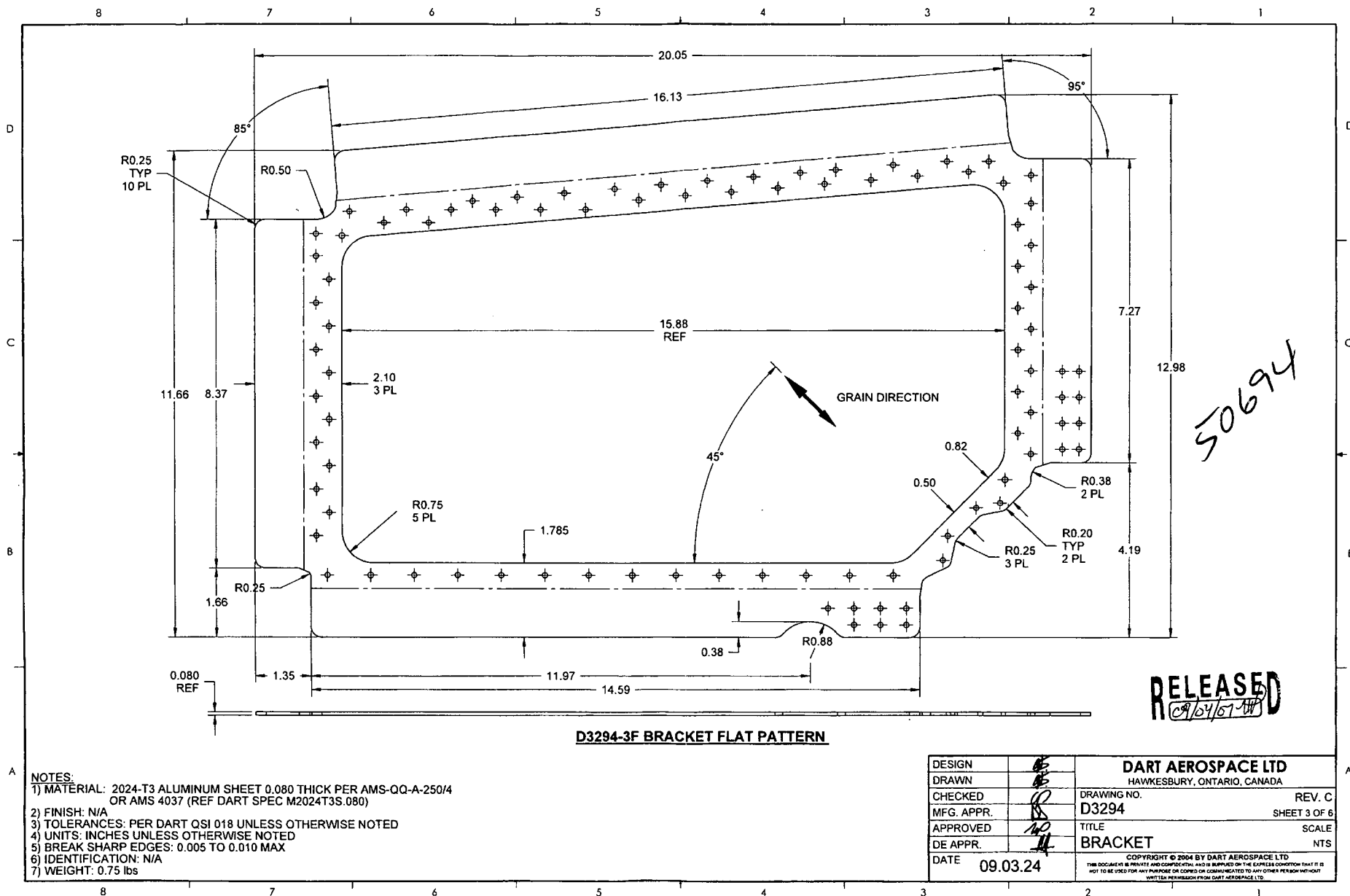
ITEM NO.	QTY. -1	PART NUMBER	DESCRIPTION
1	X	D3294-1	BRACKET ASSEMBLY
2	1	D3294-3	BRACKET
3	1	D3294-5	DOUBLER
4	15	MS20470AD4-5	RIVET

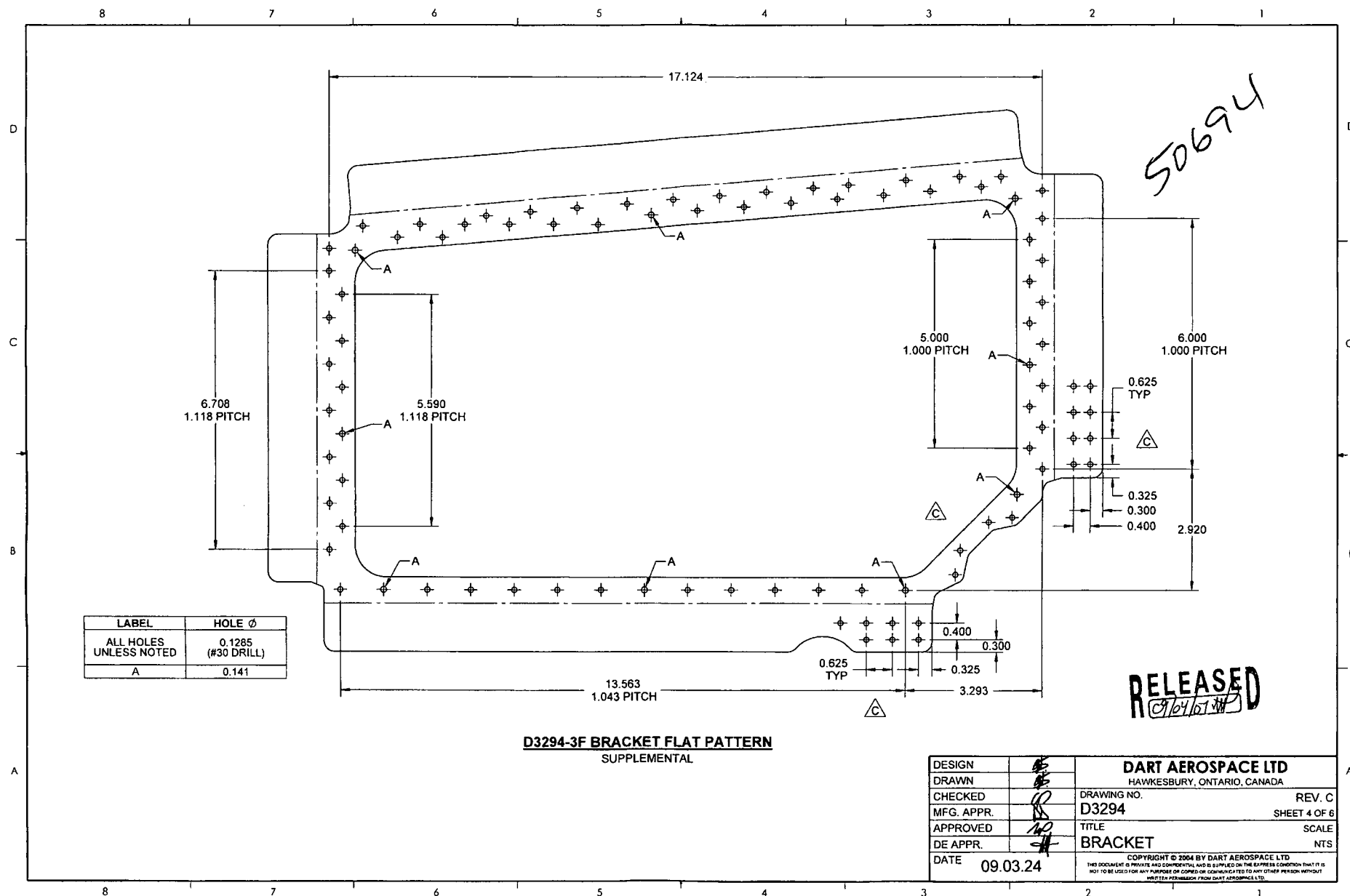
D3294-1 BRACKET ASSEMBLY

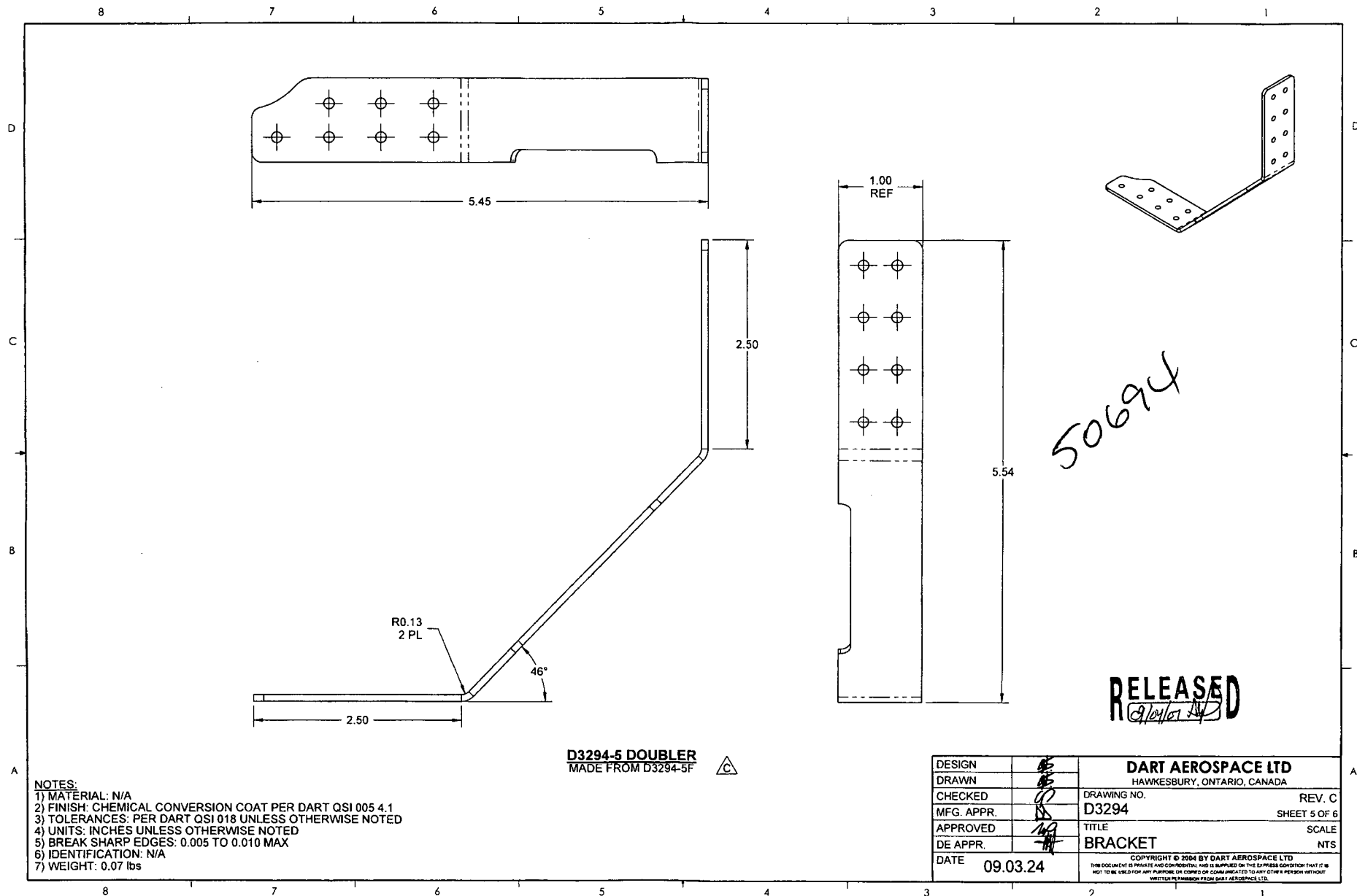
RELEASED
09/03/24

C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6.		09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3294	REV. C
MFG. APPR.		SHEET 1 OF 6	
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	09.03.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

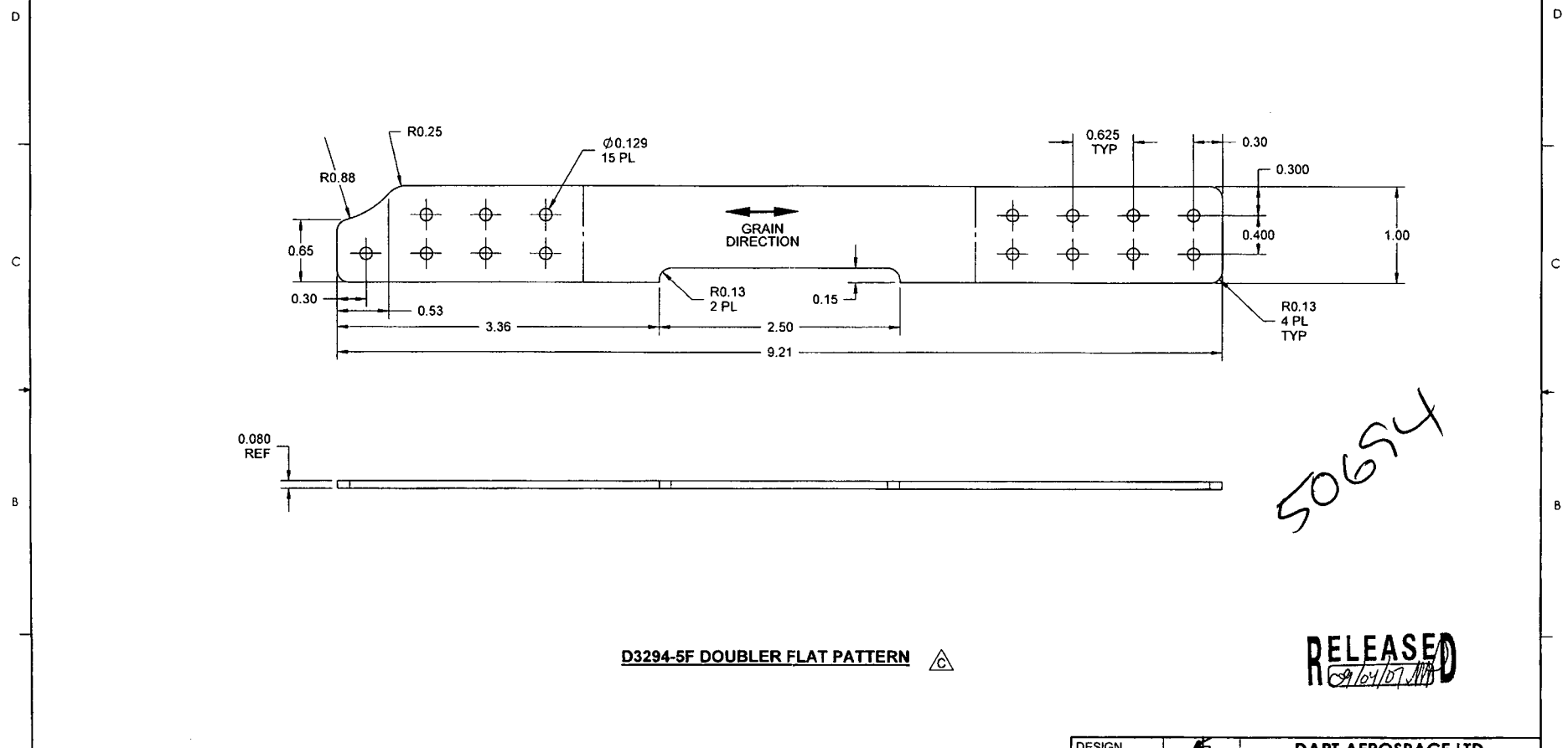
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1 AND B/N" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.83 lbs







8 7 6 5 4 3 2 1



D3294-5F DOUBLER FLAT PATTERN

RELEASED
9/04/07

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3294	REV. C
MFG. APPR.		TITLE	SHEET 6 OF 6
APPROVED		SCALE	NTS
DE APPR.		BRACKET	
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8 7 6 5 4 3 2 1